

29

Date: Thursday, 6/21/2007 2:31:46 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 206 A/B HIGH GEAR SKIDTUBE |
| Job Number | : 33078 | | |
| Estimate Number | : 10161 | | |
| P.O. Number | : N/A | Part Number | : D206642211 |
| This Issue | : 6/21/2007 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : N/A |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 33077 | Drawing Revision | : N/A |
| | Type : LANDING GEAR | Material | : N/A |
| Written By | : <u>JA 07.06.22</u> | Due Date | : 7/20/2007 |
| Checked & Approved By | : <u>JA 07.06.22</u> | Qty: | 1 Um: Each |
| Comment | : Est Rev: J 04.08.06 Revised Step 4 per CHG003 KJ/JLM J 0 4.08.06 | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



①

KS 07.07.11

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP206-642-211 CHG004

E 7/19/17

| | | |
|-----|--------|-------------------------------------|
| 2.0 | 33078A | HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B |
|-----|--------|-------------------------------------|



Comment: Sub-Component HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

D206-642-241 B 33078A

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|------------|-----------------|
| 4.0 | D206651041 | 206 A/B GHW Kit |
|-----|------------|-----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D206-651-041 GHW Kit

B30235

| | | |
|-----|-------|---------|
| 5.0 | D2652 | Bushing |
|-----|-------|---------|



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2652

Bushing

B34074

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 33078

Part Number: D206642211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655

Tow Ring

B32280

7.0

D26651

Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2665-1

Saddle

B32505

8.0

D26661

Saddle, LH, Fwd, Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2666-1

Saddle

B29668

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

B33667

10.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Batch:

B32778

11.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

B32626

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 33078

Part Number: D206642211

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M104625

13.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M100857

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M105257

15.0

AN57A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-7A

Bolt

M104623

16.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-11A

Bolt

M104746

17.0

AN644A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN6-44A

Bolt

M102079

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 33078

Part Number: D206642211

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer M104885

19.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

25 AN960JD416

Washer M104746

20.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD516

Washer M104156

21.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN960JD616

Washer M104937

22.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3) M104936

23.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

M104248

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR SKIDTUBE

Job Number: 33078

Part Number: D206642211

Job Number:



Seq. #:

Machine Or Operation:

Description :

12 MS21042L4 Nut (or -4) _____

24.0

MS21042L6

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L6 Nut (or -6) M104021

PC 7/9/12 (1)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

EO 12/08/12

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-211

Location: _____

PC 7/9/12 (1)

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

EO 12/09/12 (1)

Job Completion



U 12/09/18

33078A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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QA: N/C Closed: _____ Date: _____

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Process Sheet

29

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|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B |
| Job Number : 33078A | |
| Estimate Number : 10163 | |
| P.O. Number : N/A | Part Number : D206642241 |
| This Issue : 6/21/2007 | Drawing Number : D2650 REV E |
| S.O. No. : N/A | Project Number : N/A |
| Prsht Rev. : NC | Drawing Revision : E |
| First Issue : N/A | Material : N/A |
| Type : LANDING GEAR | Due Date : 7/20/2007 |
| Previous Run : 33077A | Qty: 1 Um: Each |
| Written By : <i>[Signature]</i> | |
| Checked & Approved By : <i>[Signature]</i> 07.06.22 | |
| Comment : Est Rev: M 04.12.02 Revised procedural steps KJ/JLM | |

Additional Product



Job Number: 

| Seq. #: | Machine Or Operation: | Description : |
|---------|---|---|
| 1.0 | DC | DOCUMENT CONTROL |
| |  |  |

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-241 CHG003

N/A 07.06.22 *[Signature]*



| | | |
|-----|---|---|
| 2.0 | D2620 | Bent 206 Skidtube |
| |  |  |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD *B-22754 BE 07-07-19*

| | | |
|-----|---|---|
| 3.0 | D32861 | Doubler |
| |  |  |



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler *B-333092*

7-8-2



| | | |
|-----|---|---|
| 4.0 | D2647 | Cap |
| |  |  |

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap *B-22328 BE 07-07-19*

| | | |
|-----|---|---|
| 5.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
| |  |  |

Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

BE 07-07-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

BE 07-07-19

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

M104907/M104221

BE 07-07-19

4-Grind weld flush to cap on top surface only.

BE 07-07-19

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

DP 7-7-24

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

78-2

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

7-8-3

15-C'sink GHW rivet holes as per Dwg D2650

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Gr 07/08/07 (XL)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

ND
7-8-9

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pr 07-08-09 (1)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-08-14 (1)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

7-8-14

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Pr 07-08-14 (1)

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet M01793 (52)

7-8-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #: Machine Or Operation: Description:

13.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

B 33418

7-8-23

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date:

7-8-23

Time:

14:00

Finish Date:

7-8-27

Time:

7:00

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

M104989

Sikaflex expire date:

8-1-1

7-8-23

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-8-27

16.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 D2649

Crossbolt spacer

B 33214

07-08-27

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B 32781

BE 07-08-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/08/22 | # | While Piloting employee marked up 5 Racks and created a mark in the skid tube. Not dead at all E.C. Humming error | <i>[Signature]</i> | Remove the fire (N/A) marked Racks. Built out mark in the skid tube. and the E.C. is not <i>is</i> *QC #5 inspect* | <i>11</i> | <i>En</i> 07/08/22 | <i>[Signature]</i> | <i>[Signature]</i> |
| | | | N/A <i>[Signature]</i> | Reinstall the Racks. to 300-4-54. M.B. | | | | |
| | | | | | | | | |

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Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M 104221 BE 07-08-27

2-Grind welds flush as per Dwg D2650.

N 7-8-28

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE BE 7-8-28

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

DP 7-8-29

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M103525 (2) N 7-8-30

20.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets

M102 SIS (2) N 7-8-30

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate *M 30446**(1) N 7-8-30*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:32:22 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

R 7-8-30

23.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/31

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

In 07/08/31

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M. H

07/09/10

(1K)

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

m 105068

FL 07/08/10 (1)

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MM 07 04 12

(1)

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

B32465

FL

29.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

B31889

FL 07/09/12 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:32:22 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-21

Wearshoe

027115

FL

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-33

Wearshoe

032281

FL

32.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

0302510

FL

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description Batch

44 ALS4-1032-130 Inserts

m102475

or (see QSI 017)

FL

34.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description Batch

44 AN960JD10L

Washer

m104885

FL 07/09/12 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:32:22 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw

m105433

FL

36.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

D32576

FL

37.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

B31488

FL

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

m15194

FL

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

m103338

FL

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

m104989

FL 07/09/12 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:32:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 08-01

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

FL

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646

Aft Cap

B31335

42.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw

M105433

43.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer

M106885

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

M104989
08-01

> FL 07/09/12 ①

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M105386

a.m 07.09.14

①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/19

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:32:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B

Job Number: 33078A

Part Number: D206642241

Job Number:



* Seq. #:

Machine Or Operation:

Description :

45.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Er 02/02/17

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 02/02/17

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location: _____

PPP Rev: _____

PPP 33078

02/02/17 (1)

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

02/09/17 (1)

Job Completion



02/09/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>1/1</i> | DRAWN BY <i>1/1</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2650 | REV. E SHEET 1 OF 5 |
| DATE 06.03.30 | | TITLE 206/407 SKIDTUBE ASSEMBLIES | SCALE NTS |
| A | 97.03.25 | NEW ISSUE | |
| B | 97.06.26 | AS MANUFACTURED CHANGES | |
| C | 97.10.29 | CHANGE HOLE PATTERN AND FRONT END | |
| D | 04.05.17 | REDRAW; INCORP. DE09136/9153/9163 - MOD GROUND HNDLNG ON D2650-1/-3 | |
| E | 06.03.30 | RMV C'BORE, CHG DRILL, ADD CHAMFER | |

RELEASED
16 04 17 *[Signature]*

| Qty -1 | Qty -3 | Qty -5 | Qty -7 | Part Number | Description |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 16 | 17 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

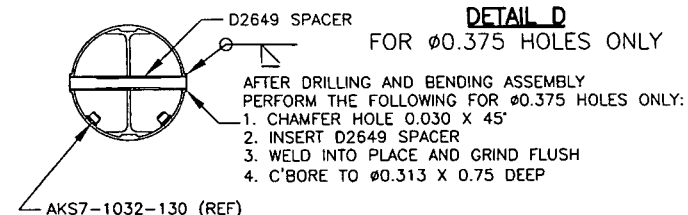
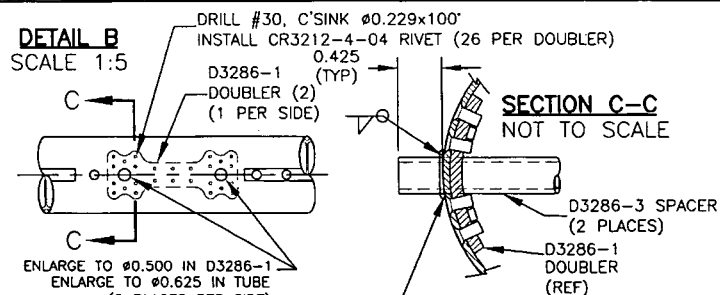
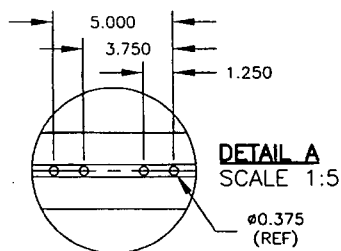
NOTES

- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 33078A

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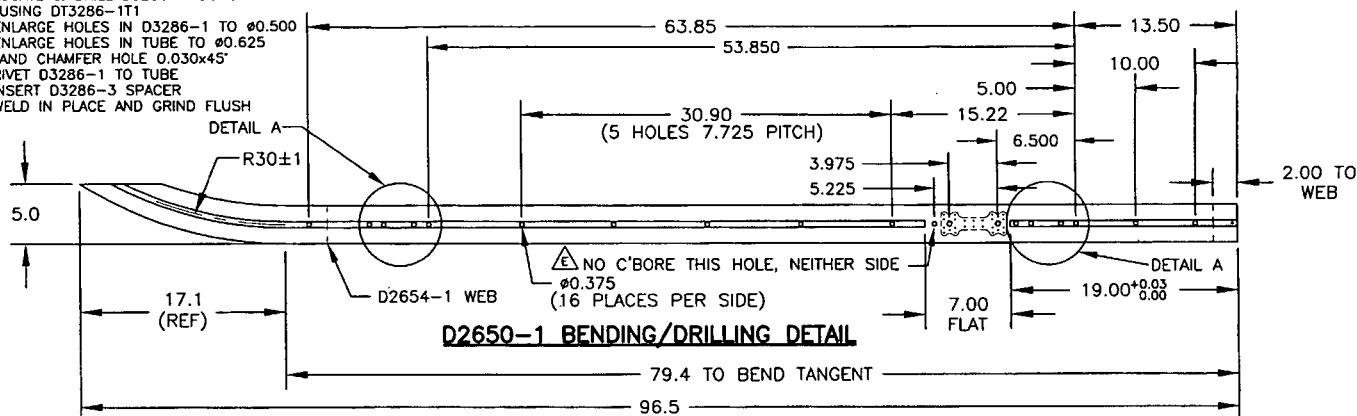
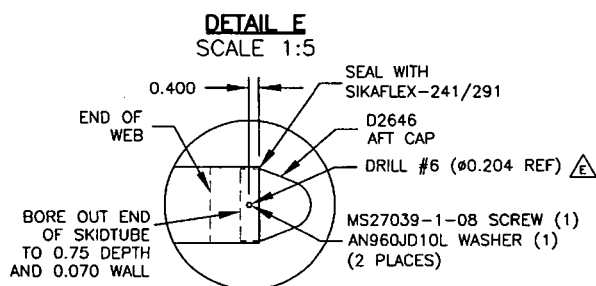
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RELEASED

06.04.17

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



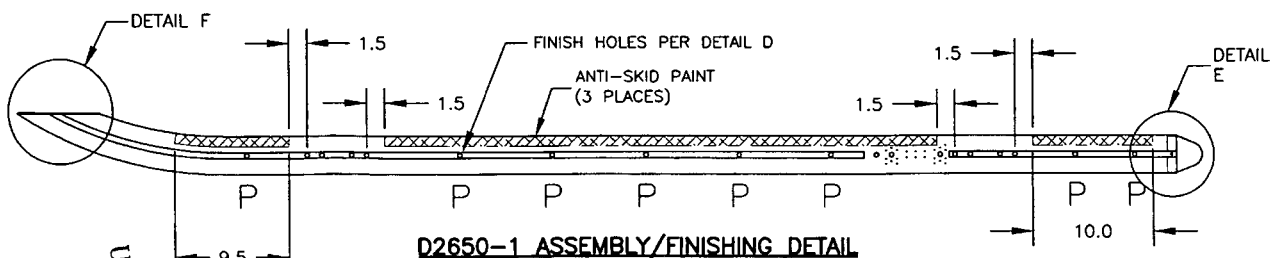
DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH




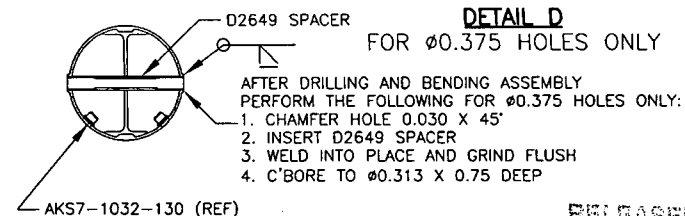
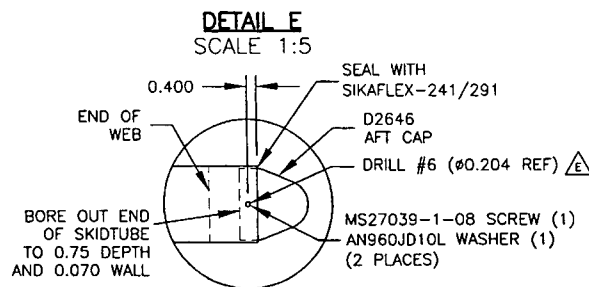
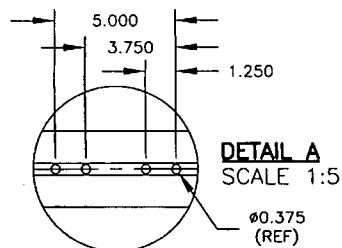
REMOVE RIDGE ON INSIDE OF SKIDTUBE LEAVE 0.070 MIN.



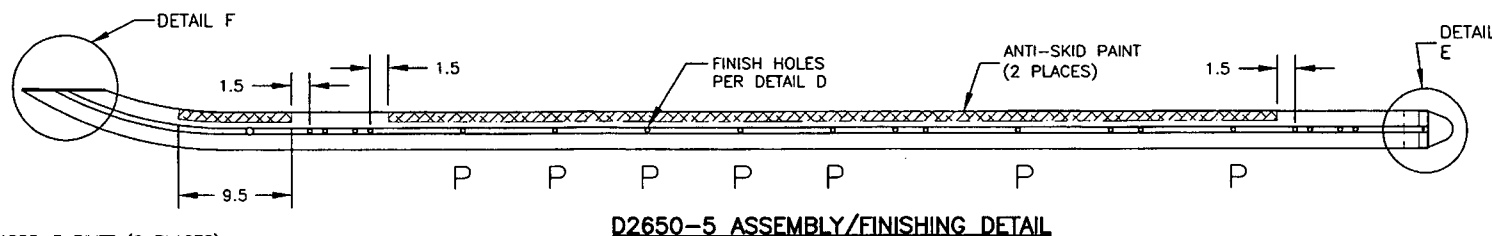
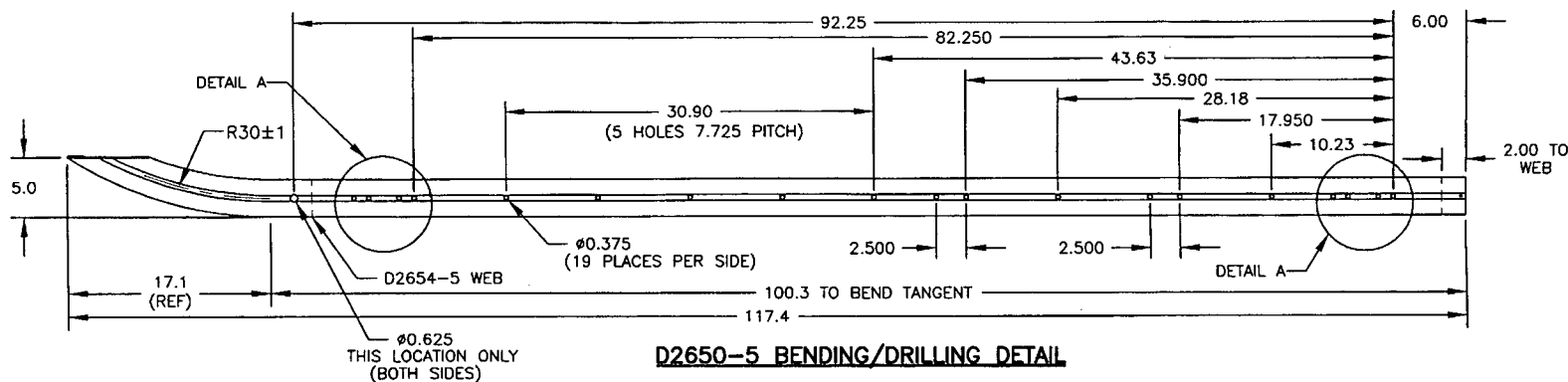
NO. 33078A
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
SHOP COPY
RETURN TO
ENGINEERING

| | | | | | | | |
|---|--|---------|----------|----------|----|-------------------------------|--------------|
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| | | DATE | 06.03.30 | | | D2650 | SHEET 2 OF 5 |
| | | | | | | TITLE | SCALE |
| | | | | | | SKIDTUBE | 1:10 |

| | | | | | |
|--|----------|----------|---|-------------|--------------|
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| | CHECKED | APPROVED | | DRAWING NO. | REV. E |
| | DATE | TITLE | | | SHEET 3 OF 5 |
| | | | | | SCALE |
| | | | | | |
| | PH | PH | D2650 | | |
| | 06.03.30 | | SKIDTUBE | 1:10 | |



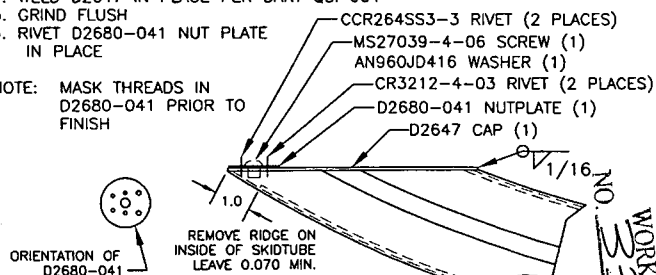
RELEASED



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



ORIENTATION OF D2680-041

NO. 33078 A
WORK ORDER
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ENGINEERING
RETURN TO
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| | | | | | |
|---------|----------|----------|----------|--|--------------|
| DESIGN | PH | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT KADLOCK, WA | REV. E |
| CHECKED | PH | APPROVED | PH | DRAWING NO. D2650 | SHEET 4 OF 5 |
| DATE | 06.03.30 | TITLE | SKIDTUBE | SCALE | 1:10 |

NO. 122

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A20664224 / B33030 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

| | Position | Vertical | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|------------------------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/> | 4G <input type="checkbox"/> |
| Tube Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/> | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/> | 4F <input type="checkbox"/> |
| Tube Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/> | 5F <input type="checkbox"/> |
| Crossbolt Spacer Welded into | Skidtube | | | |

TEST RESULTS

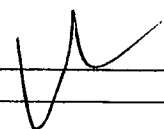
Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/09/20 Qualifier David David

Date: Thursday, 11/10/2007 2:26:44 PM
 User: Linda Lacelle

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : D206-642 |
| Job Number : 35132 | |
| Estimate Number : 10804 | |
| P.O. Number : | Part Number : Z_CUSTOM |
| This Issue : 11/10/2007 S.O. No. : | Drawing Number : ECN 1046-PAPERWORK |
| Prsht Rev. : NC | Project Number : |
| First Issue : / / Type : LANDING GEAR | Drawing Revision : |
| Previous Run : 00015 | Material : |
| Written By :  | Due Date : 18/10/2007 Qty: 1 Um: Each |
| Checked & Approved By : _____ | |
| Comment : | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D206-642-111 15614 15615
 D206-642-112 10319 25504
 D206-642-141 9075 18613
 D206-642-211 33078 32559 - 32565 - 33795 - 33776
 D206-642-212 32257 32567 - 32568 - 32568 - 33079 - 33080 - 33242
 D206-642-213 19735
 D206-642-214 24414 - 24484 - 28083 - 29084 - 32983 - 32984
 D206-642-241 28097 - 28604 - 33211 - 33342
 D206-642-311 28847
 D206-642-312 29741 - 15619 - 29742 - 29744
 D206-642-341 34557 34056 - 34555 - 34556 - 32495 - 31980
 D206-642-411 34132
 D206-642-411BL 34564 - 34563 - 34562 - 34060 - 34059 - 32502 - 31058
 D206-642-412BL 34135
 D206-642-441 31066 - 30940 - 30260 - 30265 - 24739
 D206-642-511 34522 - 34579 - 33848 - 34581
 D206-642-512 34586 - 34584 - 34583
 D206-642-513 _____
 D206-642-514 _____
 D206-642-541 _____
 D206-642-611 _____
 D206-642-612 _____

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1
 PER ECN 1046

1-11-09 SP